

Work Order ID 163605

Monday, July 03, 2017 11:30:20 AM

163605

Ship July 14

Page 1

Item ID: D3170-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 7/4/2017

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/11/2017

Req'd Qty: 10.00

10

Customer:

Reference:

DAS

21

9-89

Approvals:

Process Plan:

Date: JUL 03 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3170

Rev B

100

0.11

100

FLOW WATER JET

Waterjet

Memo

0.20

FLOW CNC Waterjet

1-Cut as per Dwg D3170

Dwg Rev: BProg Rev: B

2-Deburr if necessary

⑩

07/07/06

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.10

Quality Control

⑩

07/07/06

Monday, July 03, 2017 11:30:20 AM

Page 2

NR2

[illegible]

Work Order ID 163605

Monday, July 03, 2017 11:30:21 AM

163605

Page 3

Item ID: D3170-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 7/4/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/11/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<u>10</u>			DAS 38 JUL 9-89 2017
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				<u>10</u>			DAS 38 JUL 1-89 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : WA003	0.00 0.10				<u>10</u>			DAS 6 9-89 JUL 1 0 2017

Work Order ID 163605

Monday, July 03, 2017 11:30:21 AM

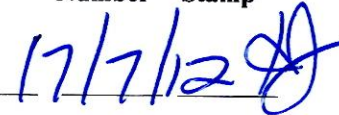
163605

Page 4

Item ID: D3170-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 7/4/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/11/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.00							
Quality Control									

17/7/12 

U 170712

Picklist Print

Monday, July 03, 2017 11:30:24 AM

Page 1

Work Order ID: 163605

163605

Parent Item: D3170-1

D3170-1

Parent Item Name: Spacer

Start Date: 7/4/2017

Required Date: 7/11/2017

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A02.10.11New issueKJ

IPP Rev:B 06-04-27 Manufactured in House JLM

IPP Rev:C Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

65.2500

0.0624

0.656842

M6061T6S 080

**

06/17/07/06

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT020

65.25

m136342

41.75

m136632

0.3

m137513

23.2

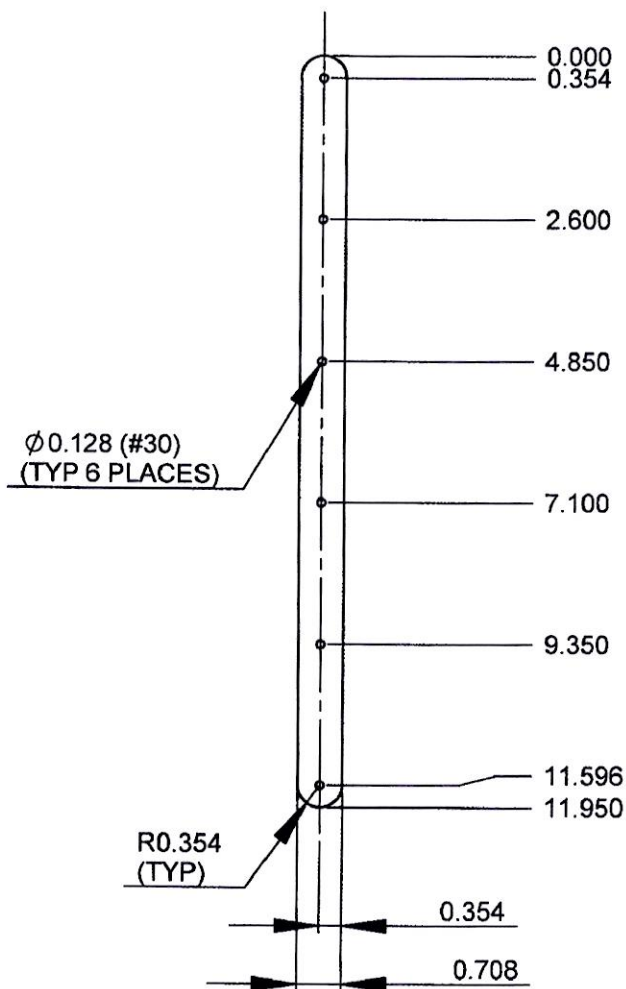
137263

.7



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3170	REV. B SHEET 1 OF 1
DATE 06.05.30		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.30	ADD 6061-T6 MATERIAL	

RELEASED
06.06.20



SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163605 M45
14-07-03

D3170-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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